

Date: Wednesday, 3/21/2007 3:40:51 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STEP LEG
Job Number : 31407B	
Estimate Number : 10353	
P.O. Number : N/A	Part Number : D2278
This Issue : 3/21/2007 S.O. No. : N/A	Drawing Number : D2278 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : E
Previous Run : 30813B	Material : N/A
Written By : <u>[Signature]</u>	Due Date : 4/10/2007
Checked & Approved By : <u>[Signature]</u>	Qty: 40 Um: Each
Comment : Est Rev:A New Issue 05-11-07 JLM	
Est Rev:B Now 6061-T6 06-06-23 JLM	

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S080 6061-T6 .080 Sheet



Comment: Qty.: 1.0306 sf(s)/Unit Total : 41.2230 sf(s)
Material: 6061-T6 sheet (QQ-A-250/8) 0.080" Thick
(M6061T62S.080) 15.459
Identify as D2278
Batch: M104326 x15 ml 07 06 08

M103961 x 25 25.765

(40)

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
1-Cut as per Dwg D2278
Dwg Rev: E
Prog Rev: E

m 07 08 09

(40)

2-Deburr if necessary

m F.

07-06-22

(38)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



ml 07 08 09



40

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



[Signature] 07-06-11

(40)



Comment: SECOND CHECK

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



(40)

Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

M-H

07/06/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: FD Date: 07/04/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: STEP LEG

Job Number: 31407B

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Pe 7/8/27 (40)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

5xL V1R

Pe 7/8/27 (40)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Pe 7/8/27 (40)

Job Completion



U 57.06.27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		Took 2x Pieces for Test of Deburring Machine. w/p. 00207	<i>[Signature]</i>	07-06-18	2		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

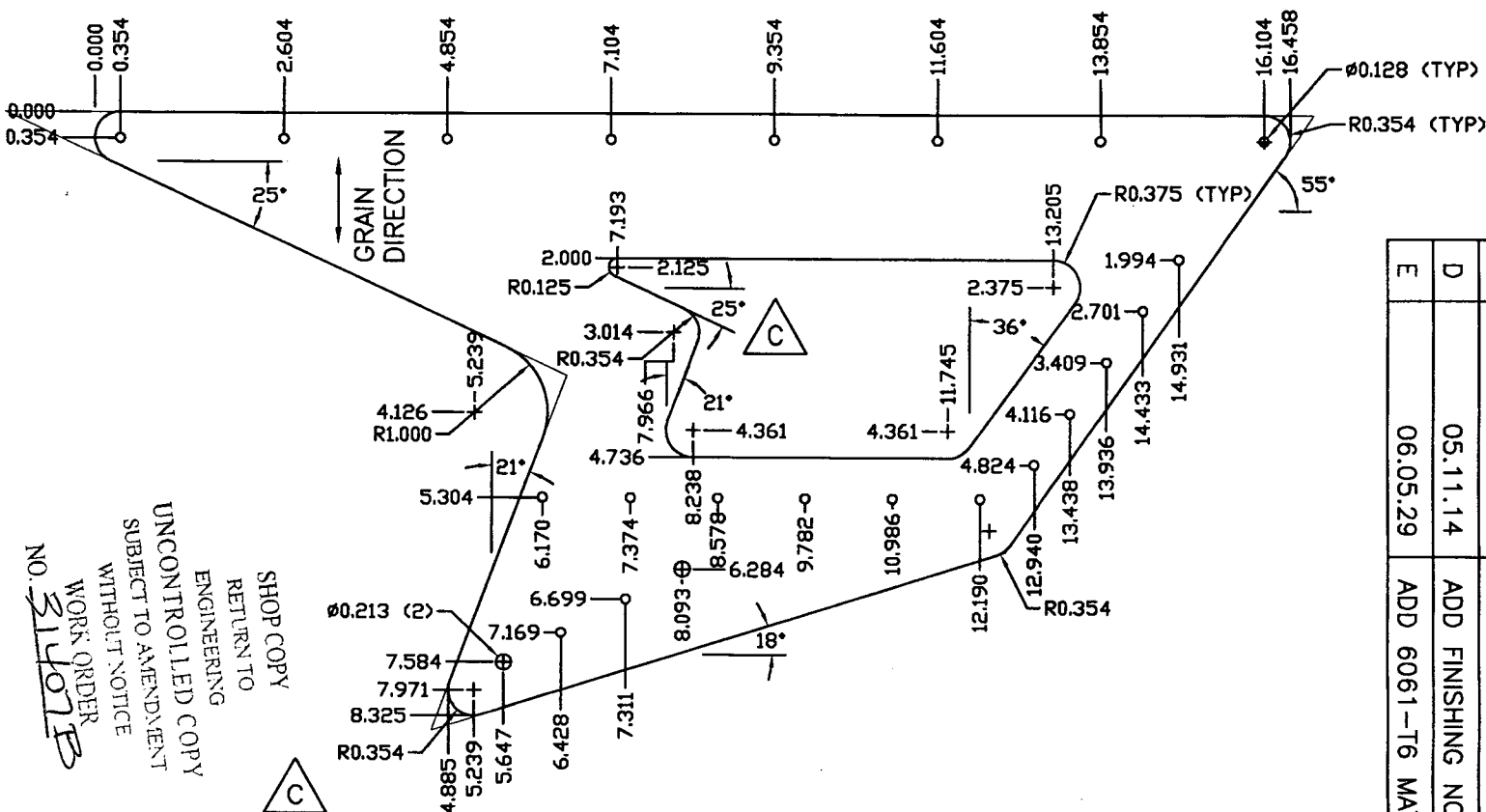
NOTE: Date & initial all entries

DART

RELEASED

06.06.20

DESIGN	DRAWN BY	DART AEROSPACE LTD	
BW	CB	HAMKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. E
PH		D2278	SHEET 1 OF 1
DATE	TITLE	SCALE	
06.05.29	LEG	1:2.5	
C	95.02.16	CHANGED RADIUS TO 0.354	
D	05.11.14	ADD FINISHING NOTE	
E	06.05.29	ADD 6061-T6 MATERIAL	



D2278 LEG

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080) OR 5052-H32 ALUMINUM SHEET (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK (REF DART SPEC M5052H32S.080)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER
NO. 31407B